

## Process Sheet

Split 815 07/06/05

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BRACKET	
Job Number	32661-1			Part Number	D35921	
Estimate Number	12811			Drawing Number	D3592 REV A	
P.O. Number	:			Project Number	NA	
This Issue	5/25/2007	S.O. No.	:	Drawing Revision	REV A	
Prsh Rev.	NC			Material	:	
First Issue	11	Type	SMALL /MED FAB	Due Date	6/10/2007	Qty: 125 Um: Each
Previous Run	32003					
Written By	<i>207-05-28</i>					
Checked & Approved By						
Comment	Est Rev:A	New Issue	07-03-26	ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	Barcode	Barcode	Barcode	Barcode
1.0	M6061T6S125	6061-T6 .125 Sheet				
	Comment: Qty.: 0.1460 sf(s)/Unit	Total : 17.5140 sf(s)				
	6061-T6 .125 Sheet		<i>ml 0705 30</i>	<i>ml 0706 04</i>	<i>125</i>	<i>125</i>
	Batch: <u>M104366</u>					
	<u>M104366</u>	***Grain must be Along 4.63*****				
2.0	WATER JET	FLOW WATER JET				
	Comment: FLOW WATER JET		<i>ml 0106 04</i>	<i>ml 0705 30</i>	<i>125</i>	<i>125</i>
	1-Cut as per Dwg D3592					
	Dwg Rev: <u>A</u>					
	Prog Rev: <u>A</u>					
	2-Deburr if necessary					
3.0	QC2:	INSPECT PARTS AS THEY COME OFF MACHINE				
	<i>ml 0706 04</i>		<i>ml 0705 30</i>			
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE					
4.0	QC8	SECOND CHECK				
	Comment: SECOND CHECK				<i>MB</i>	<i>07/06/05</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1				
	Comment: SMALL & MEDIUM FAB RESOURCE 1					
	Form as per Dwg D3592 using DT8949				<i>SB 07/06/12</i>	<i>42</i>



W/O:		WORK ORDER CHANGES					Approval Chief Eng / Prod Mgr		Approval QC Inspector		
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty				
07/06/05	2	REPROGRAM TO REV.B TO ADD TOLING HOLES. SIZE ATTACHED AS EMAIL FOR OK ON TOLING HOLES						<i>GP</i> 07/06/05			
07/06/05	5	Split w/o			SB	07/06/05	85	<i>J</i> 07/06/12			
07/06/05	5	Split w/o			SB	07/06/12	42	<i>J</i> 07/06/12			

Part No:

PAR #:

Fault Category:

NCR: Yes  NoDQA: 

Date: 07/06/05

QA: N/C Closed:

Date:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/04	2.0	125 parts scrapp. Parts needed extra holes for the bending tool.	GP 07/06/04 p/r	SCRAPP parts, and replace to Rev. B, under Preliminary Issue. See E-mail	W 01/06/04	J 07/06/04	GP 07/06/04 p/r	J 07/06/04
			QS1042	Scrap: destroy parts	SB 07/06/04	SB 07/06/04	QS1042	

NOTE: Date &amp; initial all entries



## Process Sheet

Ar: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Number: 32661

Part Number: D35921

Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP




Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

POSITIVE RECALL

Identify and Stock

EFFECTIVE 07.06.05 AUTH LLLocation: W.A.RELEASED 07.06.05 DATE QP

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





**Jason Murdoch**

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**From:** Daniel Campbell [dcampbell@dartaero.com]  
**Sent:** Thursday, May 31, 2007 9:41 AM  
**To:** 'Beckett, Bill'; Bedford, Sue; 'Bell, Christopher'; Campbell, Daniel; 'Charbonneau, Eric'; 'Elsliger, Leanne'; 'Fuentes, Roberto'; Golden, Brigitte; 'Johnston, Kim'; 'Lacelle, Linda'; mbellavance@dartaero.com; 'Menard, Jean-Luc'; 'Murdoch, Jason'; phum@dartaero.com; 'Provencal, Chris'; 'Sheldon, Susanne'; 'Shepherd, David'; 'Stow, Dan'; 'Trepanier, Dale'; Willems, Sian  
**Subject:** D3592-1 REV. A – UNDER REVIEW –

FYI,

D3592-1 is under review.

Essentially, the revision will consist of adding two 0.128 dia. tooling holes to assist in bending the part.

Bluefiles, CHG #, and in-stock items are not affected by this change.

Estimates for the D3592-1 should be placed under review.

Production is aware of this change and current production has already been modified.

**Daniel Campbell**

**Co-op Student**

**DART** aerospace Ltd.

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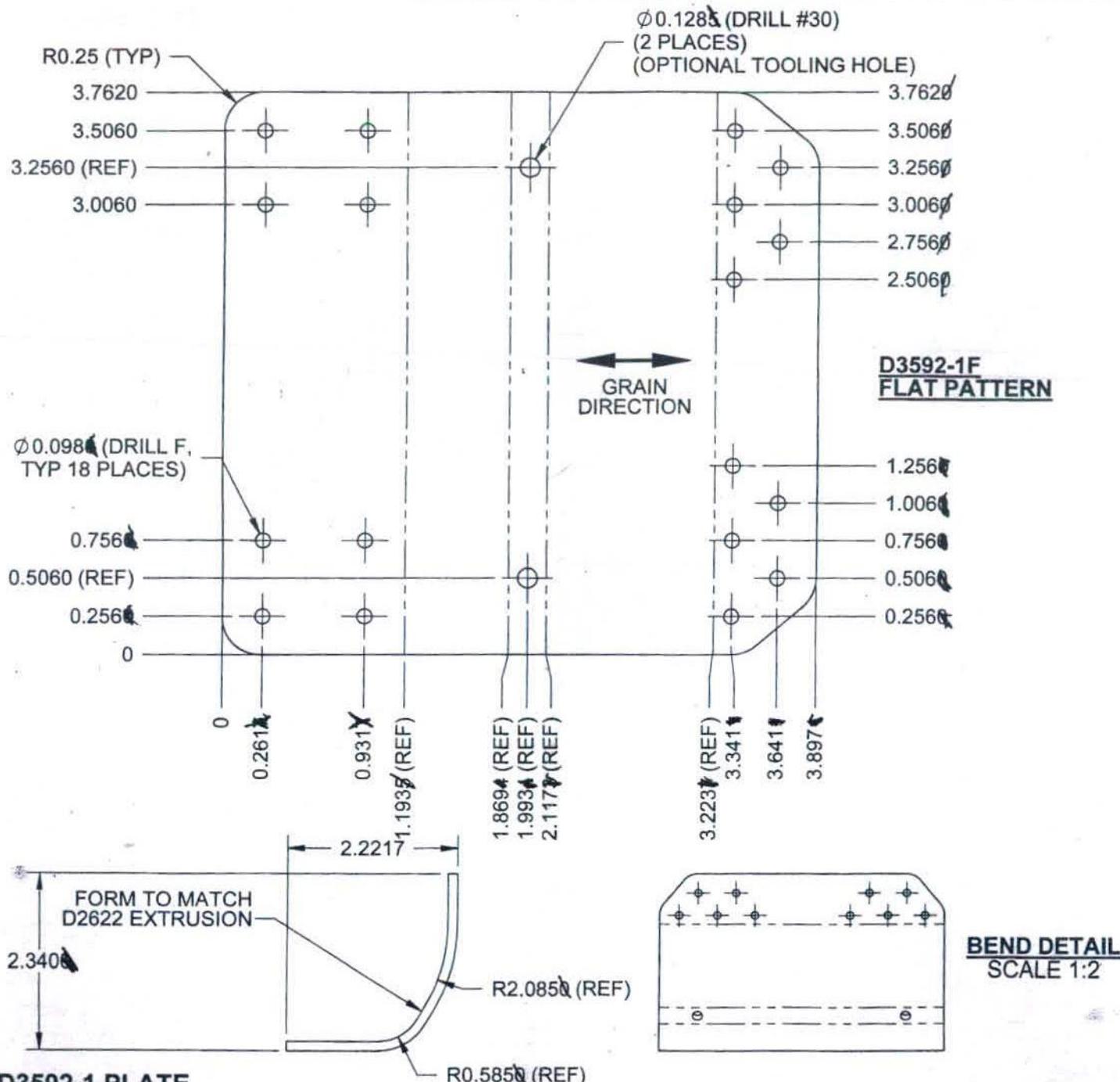
E-mail: [dcampbell@dartaero.com](mailto:dcampbell@dartaero.com)

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PRELIMINARY ISSUE  
9P 07.06.04

DESIGN <i>9P</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3592	<i>Ra. B</i> REV. A SHEET 1 OF 1
DATE 07.01.15		TITLE PLATE	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	



D3592-1 PLATE

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX



Description: Bracket

Part Number: D3592-1

Inspection Dwg: D3592 Rev: B

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## FIRST ARTICLE INSPECTION CHECKLIST

 First Article  Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.128$	$+0.005-0.001$	0.129	✓		VERN	
B $\phi 0.098$	$+0.004-0.001$	0.099	✓		VERN	
C 0.506	$+(-0.010)$	0.510	✓		VERN	
D 0.256	$+(-0.010)$	0.260	✓		VERN	
E 0.766	$+(-0.010)$	0.760	✓		VERN	
F 3.256	$+(-0.010)$	3.260	✓		VERN	
G 0.261	$+(-0.010)$	0.265	✓		VERN	
H 1.993	$+(-0.010)$	1.995	✓		VERN	
I 3.341	$+(-0.010)$	3.346	✓		VERN	
J 3.641	$+(-0.010)$	3.645	✓		VERN	
K 3.897	$+(-0.010)$	3.902	✓		VERN	
L 3.762	$+(-0.010)$	3.766	✓		VERN	
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M. M.
Date:	07/06/04

Audited by:	MS
Date:	07/06/04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		→ New Issue	KJ/RF	



